

Date: Monday, 1/22/2007 7:42:58 AM
 User: John Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 CARGO MIRROR
Job Number	: 30335	Part Number	: D044715011
Estimate Number	: 10095	Drawing Number	: D3243REV A
P.O. Number	: NA	Project Number	: N/A
This Issue	: 1/22/2007 S.O. No. : NA	Drawing Revision	: A
Prsht Rev.	: NC	Material	: Manufacture in multiples of 10
First Issue	: NA Type : SMALL /MED FAB	Due Date	: 1/30/2007 Qty: 10 Um: Each
Previous Run	: 29561		
Written By	: <u>SA 01.01.22</u>		
Checked & Approved By	: <u>SA 01.01.22</u>		
Comment	: Est Rev:A 04.02.18 New issue KJ/JLM Est Rev:B 06-04-28 Manufactured on Water Jet JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011 CHG001

SA 01.01.22
 07.01.24

2.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.5359 sf(s)/Unit Total: 5.3592 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: M18556

SA 07/01/28

3.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SA 07/01/28 (10)
 SA 07/01/29 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07/01/28 (10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07/01/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:42:58 AM
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Ship 28/11
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 30335

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



PSD

Comment: NC BRAKE

Bend as per Dwg D3243

SB 07/11/20 (9)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SA 07/11/21 (9)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FD 07/11/21 (9)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-11-26 (9)

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 FE-032EF

Insert

m102973

1 D3243-1(Ref)

Bracket

MF 07-11-24

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

MF 07-11-24 (9)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/11/26 (9)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI-005 4.3

FD 07/11/27 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D044-715-011 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/28
 QA: N/C Closed: _____ Date: _____

NCR: <u>30335</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/14/20</u>	<u>6</u>	<u>1 piece was out of tolerance at the set-up R.C. Hamman error/sched first part</u>	<u>[Signature]</u> <u>05/14/20</u>	<u>Scrap & destroy no replace</u>	<u>SB</u> <u>07/14/20</u>	<u>[Signature]</u> <u>07/14/21</u>	<u>[Signature]</u> <u>05/14/20</u>	<u>[Signature]</u> <u>07/14/21</u>

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:42:58 AM
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Process Sheet

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Drawing Name: R44 CARGO MIRROR

Job Number: 30335

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9X
M 07/11/27

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 D1048 Clamp

⑦ 1329769
⑪ S4 1330373

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 D1049 Saddle

⑦ 1329770 S4

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2010-104 Arm

② 32386 ⑦ 31100 S4

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2011-101 Mirror

⑥ 1334886 S4

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
4 ALS4-1032-130 Insert

⑦ 1105730 7/11/27 S4 9X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:42:58 AM
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Process Sheet

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Drawing Name: R44 CARGO MIRROR

Job Number: 30335

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A Bolt M103641

sq

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10 Screw M15072

sq

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L Washer M104374

7/11/27 sq (K9)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5/11/28 (K9)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location: Rev A

07/11/28 (K9)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.28

Job Completion



07.11.28

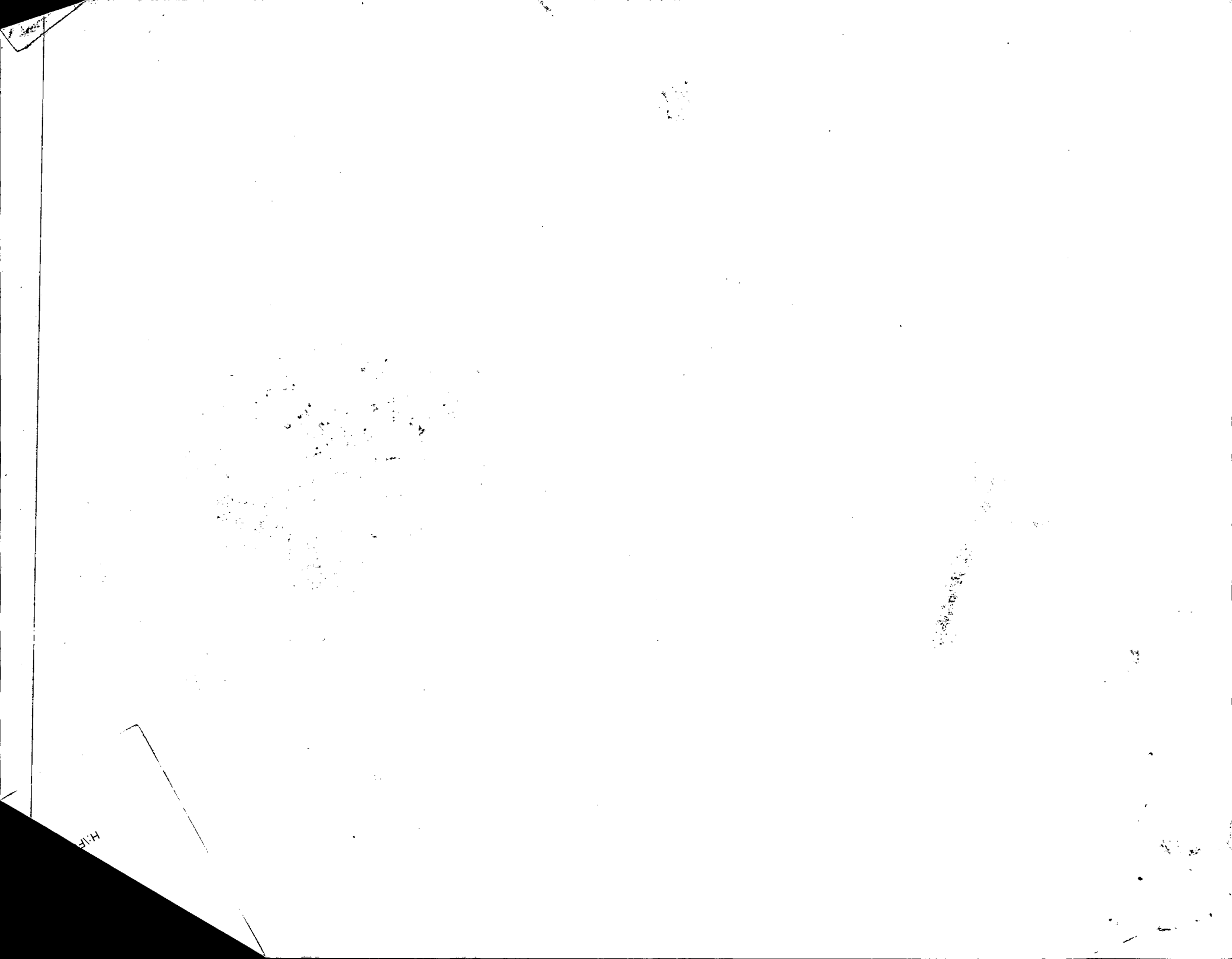
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

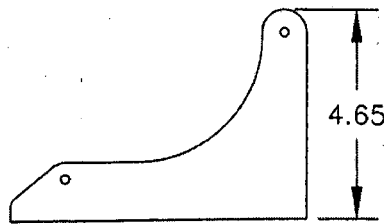
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 $\begin{smallmatrix} +0.030 \\ 0.000 \end{smallmatrix}$ 11.920
11.420 $\varnothing 0.201$
(TYP 4 PLACES) $\varnothing 0.290$
(TYP 4 PLACES)

1.375

5.273

3.714

0.500

0.000

RELEASED
04.02.03

8.581

8.206

7.706

4.214

R0.25 (TYP)

3.339

R0.38 (TYP)

5.494

6.560

5.810

5.360

GRAIN
DIRECTIONSHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 30335R2.75
(TYP)D3243-1
FLAT PATTERNR0.50
(TYP)**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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272